

Work Order ID 74522

Monday, October 03, 2011 4:02:30 PM



Page 1

Item ID: D2587

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Slug, 350 Hinge

Start Date: 9/30/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/10/04 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2587

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2587 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-
Deburr if necessary

6061 . 640

B11-10-20



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-10-20

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11 10 28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				40	132	11-1-1	
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							40X J M / 11/11/01
150 Packaging Packaging	Identify as per dwg & Stock Location: 017 Memo	0.00 0.00							11/11/01 (40)

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Required Date: 10/14/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/02

umf 11-11-01

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 4:02:47 PM

Page 1

Work Order ID: 74522

Parent Item: D2587

Parent Item Name: Door Slug, 350 Hinge



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ D ☐ 04.05.31 ☐ Step 2 changed ☐ KJ/JLM ☐
IPP ☐ E ☐ 06.07.31 ☐ Waterjet ☐ EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

100

sf

93.8000

0.016

0.336842

1.



B11-10-20

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

93.8

113004

7.5

117653

86.3

117653

(40)

Dart Aerospace Ltd

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Dart Aerospace Ltd

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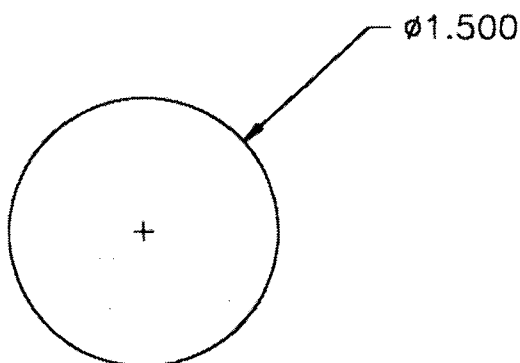


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED M. M.	APPROVED M. M.	D2587	SHEET 1 OF 1
DATE 96:07:11	TITLE DOOR SLUG		SCALE 1:1
AI KJ 03.09.16		ADD 6061-T6 OPTION	

RELEASED
96 07 23 B.W.

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED
SUBJECT TO ATTENDANCE
WITHOUT NOTICE
WORK ORDER
NO. 745.22
M.C.J.

11/10/04



OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B) AI

MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ETCH, ALODINE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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